

Work Order ID 80636-1

February-24-12 3:22:10 PM

23mm *806.36*

Page 1

Item ID: D350-567-141

Revision ID:

Item Name: Floor Window Closeout Installation

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Start Date: 24/02/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 15/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 12/02/27 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 9590

A B

EN 12-537

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D350-567-141 CHG001

5/12/3/20

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

12/3/13 (9) SP

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

5/12/3/20

Work Order ID 80636

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80636

Page 2

Item ID: D350-567-141

Revision ID:

Item Name: Floor Window Closeout Installation

Start Date: 24/02/2012 Start Qty: 10.00

Required Date: 15/03/2012 Req'd Qty: 10.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D350-567-141
Location:

12/360 SL 12

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

ML 12/03/20

MF
12-03-20

Picklist Print

Page 1

February-24-12 3:22:13 PM

Work Order ID: 80636

80636

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 11.11.09 new issue DD verf:JLM
12.01.23 AS PER ECN12-511 DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3802-1		Manufactured	No			110	f	554.3800	2	20			
---------	--	--------------	----	--	--	-----	---	----------	---	----	--	--	--

D3802-1

Window Seal

**

B 8/021

Location

Loc Qty

Loc Code

ST412

554.38

56881

554.38

27

(D3802-1-024) CUT (1) AT 24" AS PER DWG, PER KIT.

D4434-041

Manufactured No

110

Each

0.0000

1

10

D4434-041

Fwd Bracket Assembly

**

B81864

D4434-047

Manufactured No

110

Each

3.0000

1

10

D4434-047

Cover Assembly

**

B80658

Location

Loc Qty

Loc Code

PRE

2

77915

1

79381

1

prelim

1

74814

1

D4435-045

Manufactured No

110

Each

2.0000

1

10

D4435-045

T/R Bellcrank Cover Assembly

**

B80649 12/3/20

Location

Loc Qty

Loc Code

ENG

2

77926

1

79382

1

Picklist Print

Page 2

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Work Order ID: 80636

80636

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

D4435-9

Manufactured No

110 Each

4.0000

2

20

D4435-9

Bracket

**

B80636 SP

Location

Loc Qty

Loc Code

ENG

4

77927

2

79383

2

D4436-041

Manufactured No

110 Each

1.0000

1

10

D4436-041

Aft Bracket Assembly

**

B81865 SP

Location

Loc Qty

Loc Code

ENG

1

77907

1

D4441-1

Manufactured No

110 f

24.7270

2

20

D4441-1

Rubber Seal

**

B80763 SP

Location

Loc Qty

Loc Code

prelim

24.727

74760

24.727

(D4441-1-240) CUT (1) AT 24.00" PER KIT

AN3-3A

Purchased No

110 Each

1,007.000

7

70

AN3-3A

Bolt

**

12/3/16 SP

Location

Loc Qty

Loc Code

ST350

1007

120187

7

120423

1000

AN525-632R6

Purchased No

110 Each

0.0000

AN525-632R6

Screw

**

70
12/3/16 SP
M120519

February-24-12 3:22:13 PM

Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 80636

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

80636

D350-567-141

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

AN525-10R6

Purchased

No

AN525-10R6

Screw

110

Each

58.0000

2

20

**

Location

Loc Qty

Loc Code

ST345

32

120308

32

ST346

26

118757

23

119309

3

110

Each

542.0000

9

90

**

MS21042L06

Purchased

No

MS21042L 06

Nut

Location

Loc Qty

Loc Code

ST300

542

118354

2

119109

39

119758

1

120360

500

110

Each

4,110.000

5

50

**

MS21042L3

Purchased

No

MS21042L 3

Nut

Location

Loc Qty

Loc Code

ST300

4110

117441

16

117885

32

118451

5

118927

3

119017

3854

119075

200

February-24-12 3:22:14 PM

Shop Packet Print

Page 3

Picklist Print

February-24-12 3:22:14 PM

Work Order ID: 80636

80636

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

MS21059L3

Purchased

No

110

Each

252.0000

2

20

MS21059L3

Nut Plate

**

SP

Location

Loc Qty

Loc Code

ST301

52

118614

8

119546

44

ST302

200

120308

200

20

NAS1149F0332P

Purchased

No

110

Each

416.0000

12

120

NAS1149F0332P

WASHER

**

SP

Location

Loc Qty

Loc Code

ST275

416

117735

37

119225

176

120498

200

17317

3

120

NAS1149FN616P

Purchased

No

110

Each

1,191.000

9

90

NAS1149FN616P

WASHER

**

12/3/16 SP

(90)

Location

Loc Qty

Loc Code

ST275

1191

117317

191

120560

1000

90

NAS1149FN886P x 2

B

121039

per Kit SP

MS35206-229 x 7

B

121039

per Kit SP

MS21042L08 x 2

#

121039

SP 20x

12/3/16

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. D OR EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 1 OR EARLIER

REF CANADIAN STC: SH92-18

FAA STC: SH989NE

FAA STC: SH990NE

1.0 Purpose

The purpose of this service instruction is to add the D350-567-141 Close-out Kit, which is intended for customers wishing to operate their aircraft with the interior floor window removed. The D350-567-141 Floor Window Close-out Kit provides a barrier around the interior and exterior vertical reference floor window to prevent objects from falling into the aircraft controls when the interior floor window is removed as shown in Figure 1.

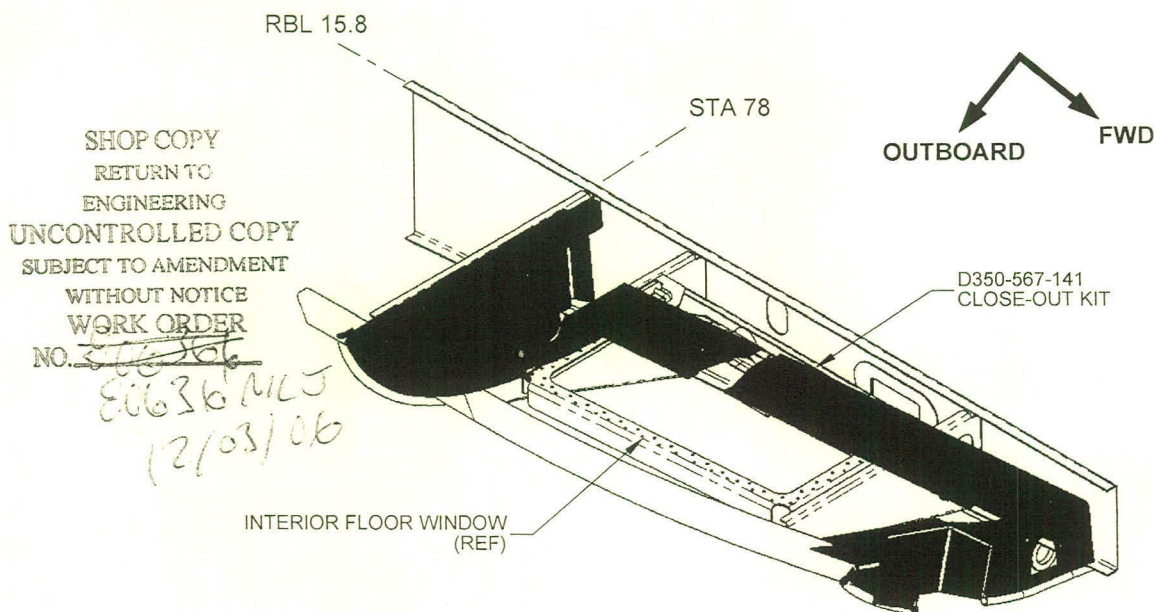


Figure 1. Floor Window Close-out Kit Installation

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 12.02.22
CERT. NO.: SH92-18
ISSUE NO.: 6

B	MS35206-229 WAS AN525-632R6; NAS1149FN616P (Qty 14) WAS (Qty 9); MS21042L06 (Qty 7) WAS (Qty 9); ADD AN525-832R7, NAS1149FN882P & MS21042L08	RF	12.02.22
A	NEW ISSUE	RF	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9590	SHEET 1 OF 12
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
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2.0 Part List

Qty -141	Part Number	Description
X	D350-567-141	FLOOR WINDOW CLOSE-OUT KIT
1	D3802-1-024	SEAL (24")
1	D4434-041	FWD BRACKET ASSEMBLY
1	D4434-047	COVER ASSEMBLY
1	D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	D4435-9	BRACKET
1	D4436-041	AFT BRACKET ASSEMBLY
1	D4441-1-240	RUBBER SEAL (24")
7	AN3-3A	BOLT
2	AN525-832R7	SCREW
7	MS21042L06	NUT (OR MS21042-06)
2	MS21042L08	NUT (OR MS21042-08)
5	MS21042L3	NUT (OR MS21042-3)
2	MS21059L3	NUTPLATE
7	MS35206-229	SCREW
12	NAS1149F0332P	WASHER (AN960-10L)
14	NAS1149FN616P	WASHER (OR AN960-6L)
2	NAS1149FN882P	WASHER (OR AN960-8L)

B

B

B

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kG	1.66 m	2.94 m-kG

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 — OK to remove D3295-041
 - D350-567-031 — OK to remove D3212-1
 - D350-567-011 — OK to remove D2214
 - D350-567-021 — OK to remove D2951
- It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

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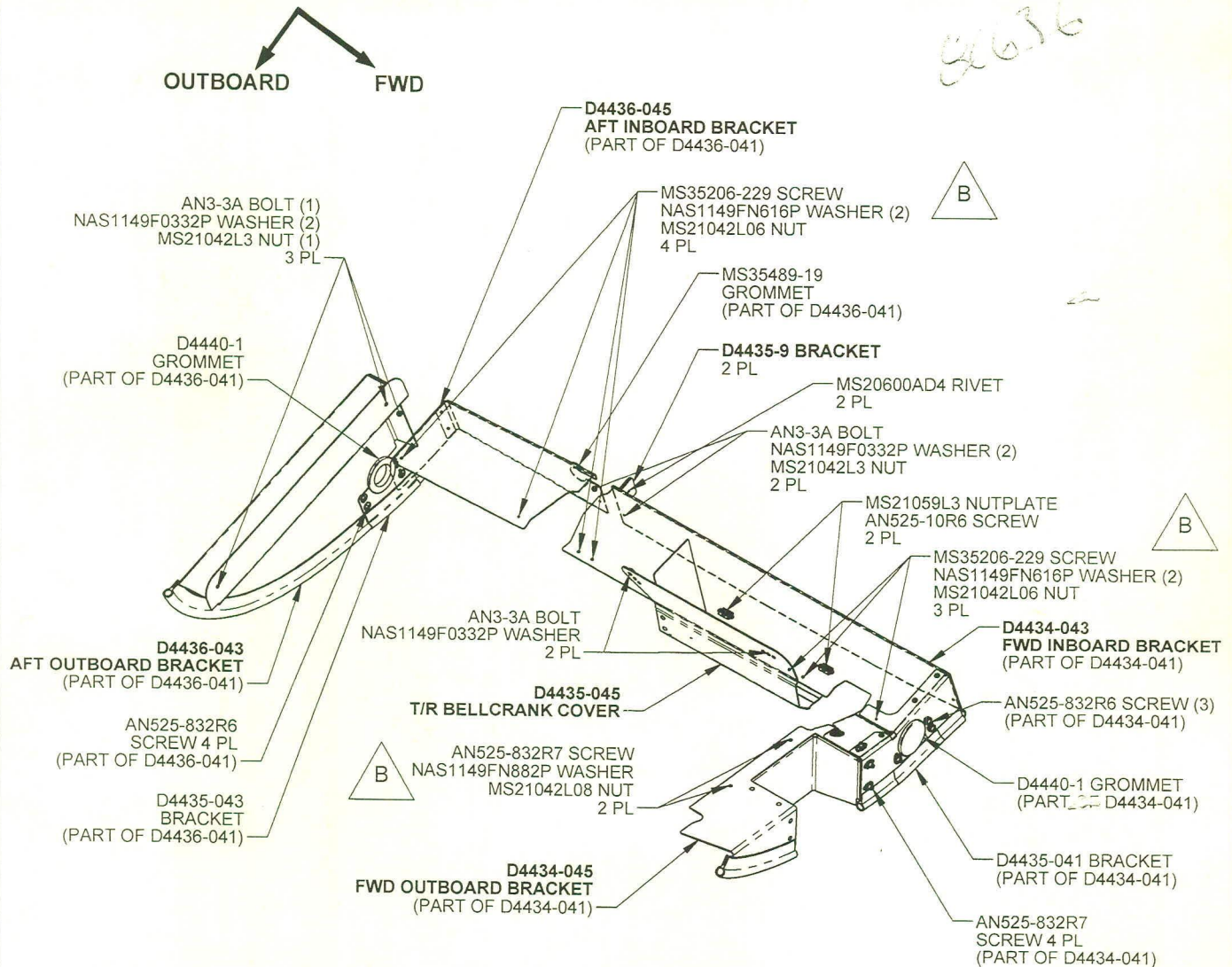


Figure 2. Floor Window Close-out Kit Installation

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80636

- 4.1 Temporarily install D4436-043 Aft Outboard Bracket and D4436-045 Aft Inboard Bracket using clecos and/or cleco clamps. Before drilling holes:
- Position the D4436-043 Aft Outboard Bracket so the flange contacts the main beam as shown in Figure 3.
 - Confirm that the D4436-043 Aft Outboard Bracket and beam angle are parallel as shown in Figure 4.
- 4.2 Temporarily install D4434-043 Fwd Inboard Bracket and D4434-045 Fwd Outboard Bracket using clecos and cleco clamps. Confirm there is no contact between D4436-045 Aft Inboard Bracket and D4434-043 Fwd Inboard Bracket and main beam gusset as shown in Figure 5.
- 4.3 If aircraft is equipped with Collective Circuit Breaker Board box trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Install D4434-047 Cover as shown in Figure 13. Note: Confirm the D4434-047 Cover fits over the Collective Circuit Breaker Board box. Adjust opening as required.
- 4.4 Drill off rivets holding plastic wire bundle stand offs. Transfer drill $\varnothing 0.144$ holes to D4436-045 Aft Inboard Bracket per Figure 6. Transfer drill 2 x $\varnothing 0.144$ holes to D4434-043 Fwd Inboard Bracket per Figure 7. Transfer drill 2 x $\varnothing 0.144$ holes for D4434-043 Fwd Inboard Bracket per Figure 8. Before drilling confirm the D4434-043 and D4436-045 brackets are flush with outboard edge of main beam flange. Assemble D4436-045 Aft Inboard Bracket and D4434-043 Fwd Inboard Bracket and wire bundle stand offs to main beam flange using MS35206-229 screw, NAS1149FN616P washer and MS21042L06 nut.
- 4.5 Install D4436-043 Aft Outboard Bracket using AN3-3A bolt and NAS1149F0332P washer and MS21042L3 nut per Figure 9.
- 4.6 Remove 2 rivets holding RH heating plastic stand off as shown in Figure 10. Position the D4435-9 Brackets on the in/outboard sides of the cross beam and transfer drill 2 x $\varnothing 0.129$ holes from crossbeam to both D4435-9 Brackets. Install D4435-9 Brackets and RH heating plastic stand off using MS20600AD4 rivets or equivalent.
- 4.7 Drill a pilot hole from D4435-9 Bracket to the D4434-045 Fwd Inboard Bracket and D4436-045 Aft Inboard Bracket and open to $\varnothing 0.191$. Install AN3-3A bolt, NAS1149F0332P washer and MS21042L3 nut as shown in Figure 10. Be sure to maintain edge distance.
- 4.8 Transfer drill 2 x $\varnothing 0.144$ holes from crossbeam to D4434-045 Fwd Outboard Bracket if holes exist in crossbeam. If holes do not exist, drill 2 x $\varnothing 0.144$ holes at either end of D4434-045 bracket as shown in Figure 11. Install AN525-832R7 Screws, NAS1149FN882P washer and MS21042L08 nuts.
- 4.9 Align D4435-045 T/R Bellcrank Cover with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12.
- 4.10 Transfer drill 2 x $\varnothing 0.098$ holes from D4435-045 T/R Bellcrank Cover to D4434-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043 Fwd Inboard Bracket as shown in Figure 12 and Figure 13. Install D4435-045 T/R Bellcrank Cover using AN525-10R6 screw, AN3-3A bolt and NAS1149F0332P washer per Figure 12 and Figure 13.
- 4.11 The D4440-1 grommets are provided to facilitate the routing of wiring harness thru the close-out kit as required. The wiring harness should be secure to the aircraft structure per AC 43.13.13-1B or AS350 Chapter 20.02.01.
- 4.12 Use the D3802-1-024 Seal to fill gaps between the brackets and the cowlings that are larger than 0.25 inch.
- 4.13 Perform travel/interference check of the flight controls to ensure there is no interference and all controls still have full travel.
- 4.14 Ensure there is a gap between the components of the D350-567-141 Close-out Kit and the aircraft structure so that the Close-out Kit does not chafe, interfere, or cause damage to the surrounding aircraft structure. In areas where the D350-567-041 Close-out Kit may contact the aircraft structure, protect from abrasion using chafing tape or a layer Proseal 890 or MIL-S-8802 class B2 sealant or equivalent as required.



CANADA
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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

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D. SHEPHERD (DE # 02)

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MFG. APPR.	N/A	DSI 9590	SHEET 4 OF 12
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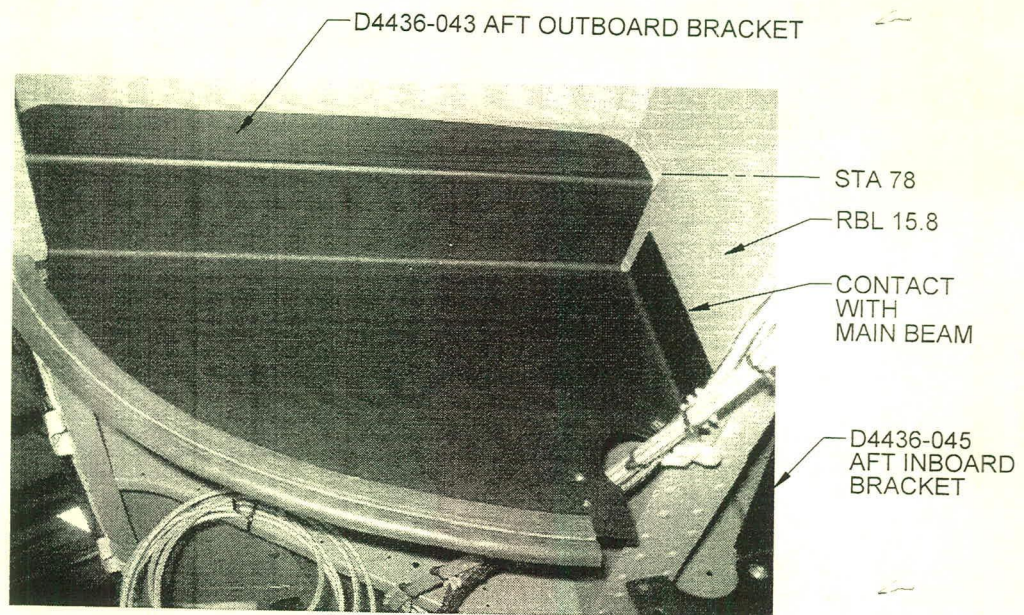


Figure 3. D4436-043 Aft Outboard Bracket Installation

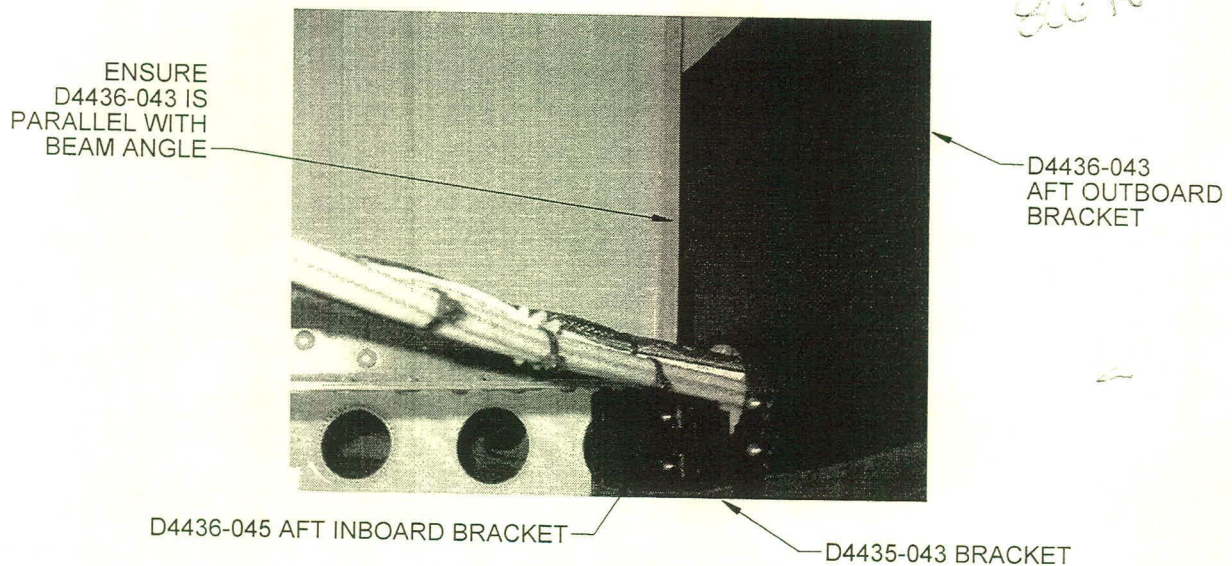


Figure 4. D4436-043 & D4435-043 Brackets Installation

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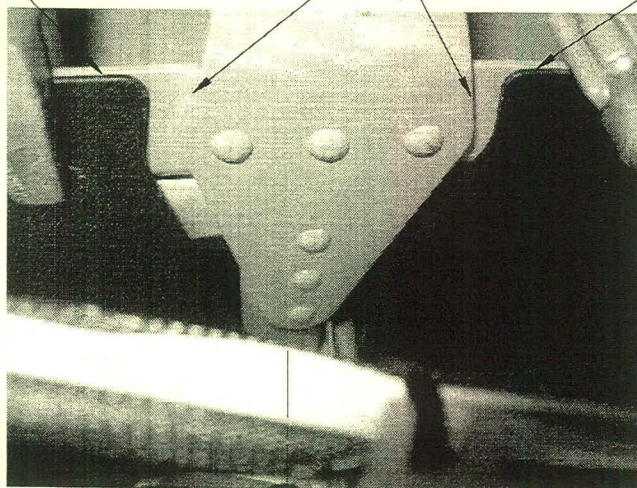
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D4436-045 AFT INBOARD
BRACKET

NO CONTACT
WITH GUSSET

D4434-043 FWD INBOARD
BRACKET

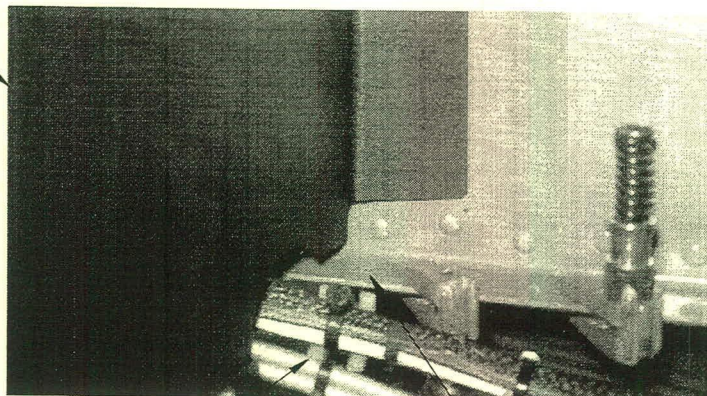
RBL 15.8 — — —



STA 70.5

Figure 5. D4436-045 & D4434-043 Brackets Installation

D4436-043
AFT OUTBOARD
BRACKET



CONFIRM
FLUSH WITH
OUTBOARD
EDGE OF MAIN
BEAM FLANGE

PLASTIC STAND OFF
REF

RIVET HOLE
FOR PLASTIC
STAND OFF

D4436-045
AFT INBOARD
BRACKET

Figure 6. D4436-043 & D4436-045 Brackets Installation

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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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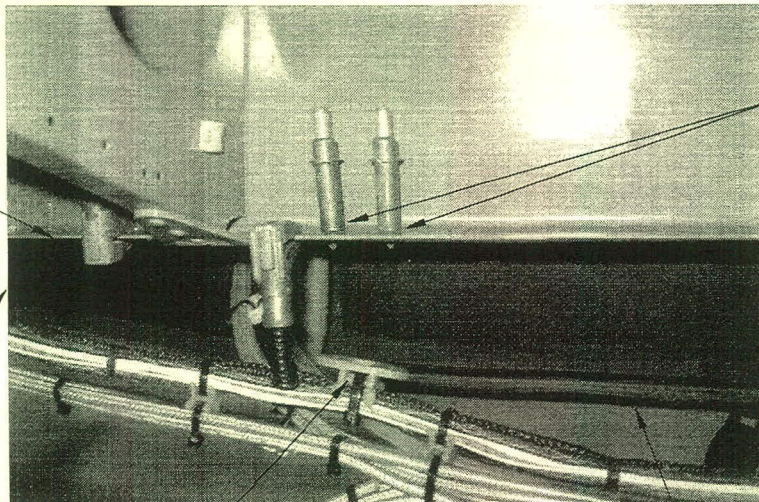
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CONFIRM
FLUSH WITH
OUTBOARD
EDGE OF MAIN
BEAM FLANGE

D4436-045
AFT INBOARD
BRACKET

PLASTIC STAND OFF
REF



RIVET HOLES
FOR PLASTIC
STAND OFF

--- RBL 15.8

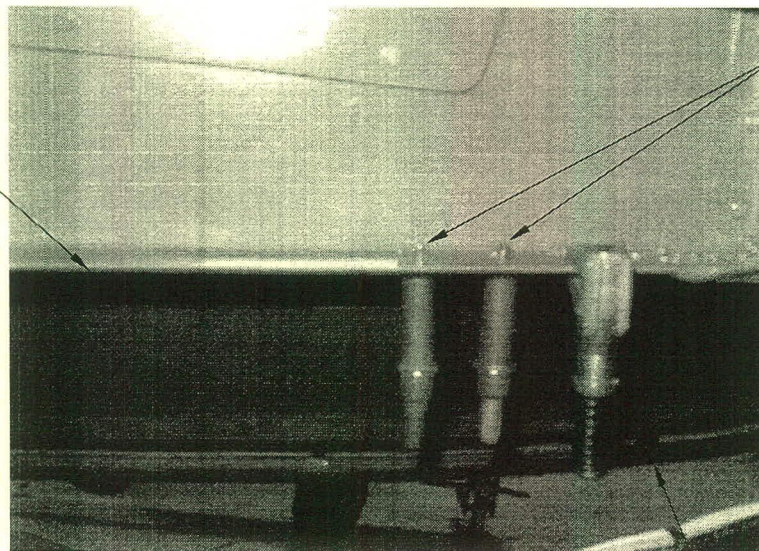
D4434-043 FWD INBOARD
BRACKET

Figure 7. D4434-043 & D4436-045 Brackets Installation

CONFIRM
FLUSH WITH
OUTBOARD
EDGE OF MAIN
BEAM FLANGE

RIVET HOLES
FOR PLASTIC
STAND OFF

--- RBL 15.8



D4434-043 FWD INBOARD
BRACKET

Figure 8. D4434-043 Fwd Inboard Bracket Installation

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INSTALL
D4436-043
AFT OUTBOARD BRACKET
USING
AN3-3A BOLT (1)
NAS1149F0332P WASHER (2)
MS21042L3 NUT (1)
3 PL

90632

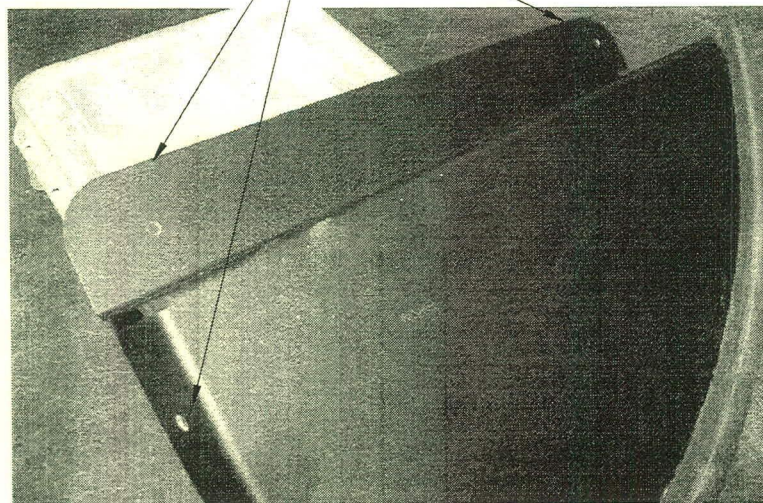
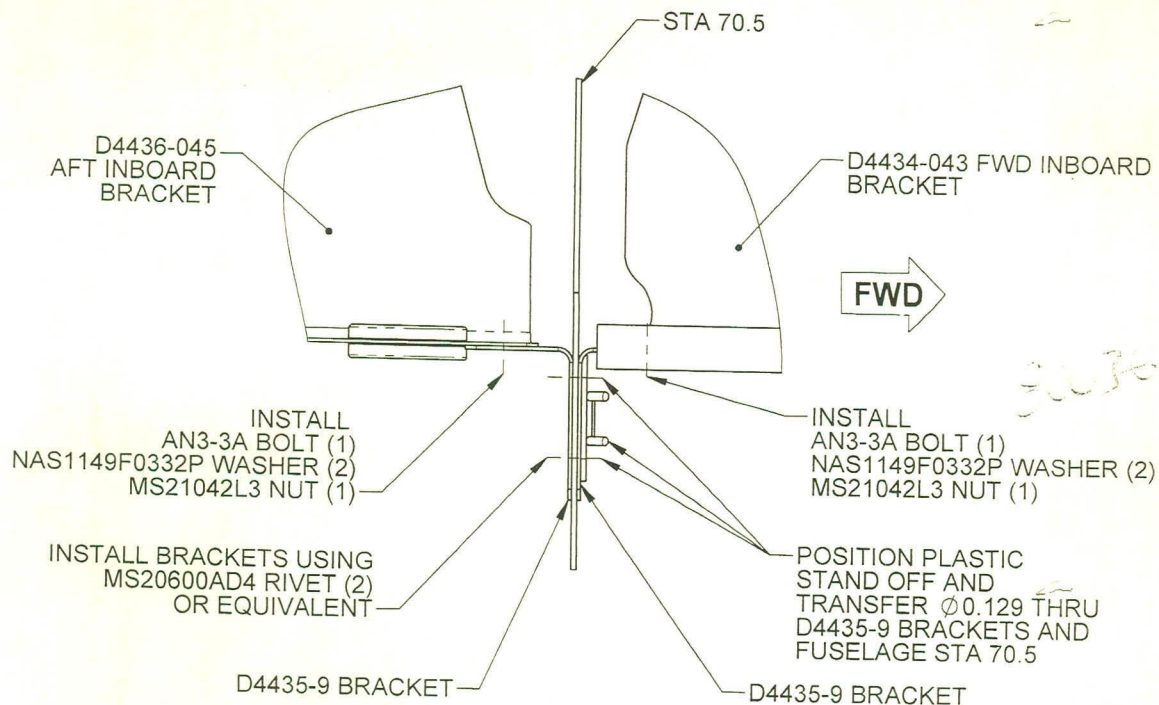


Figure 9. D4436-043 Aft Outboard Bracket Installation

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: [Signature]
D. SHEPHERD (DE # 02)
DATE: 12.02.22
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LOOKING UP AT STA 70.5

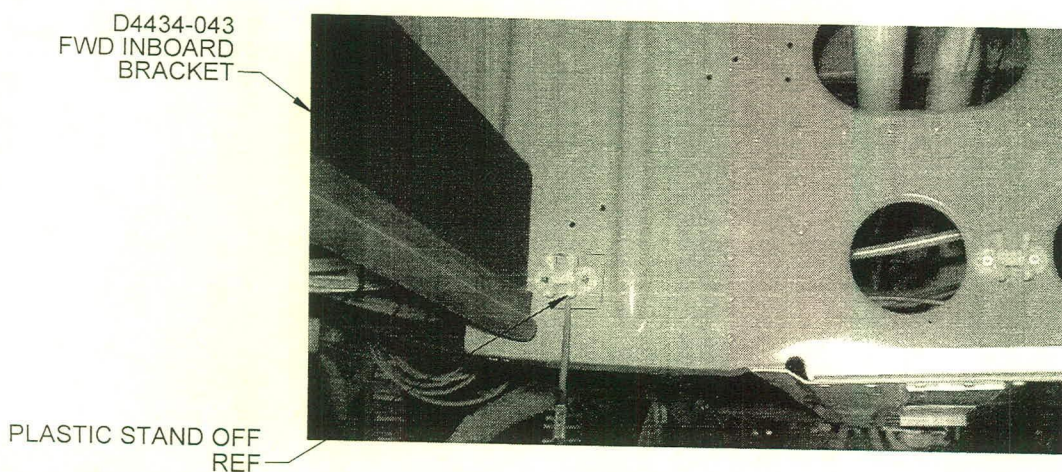


Figure 10. D4434-043 and D4435-9 Brackets Installation

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DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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RE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE OUT KIT	

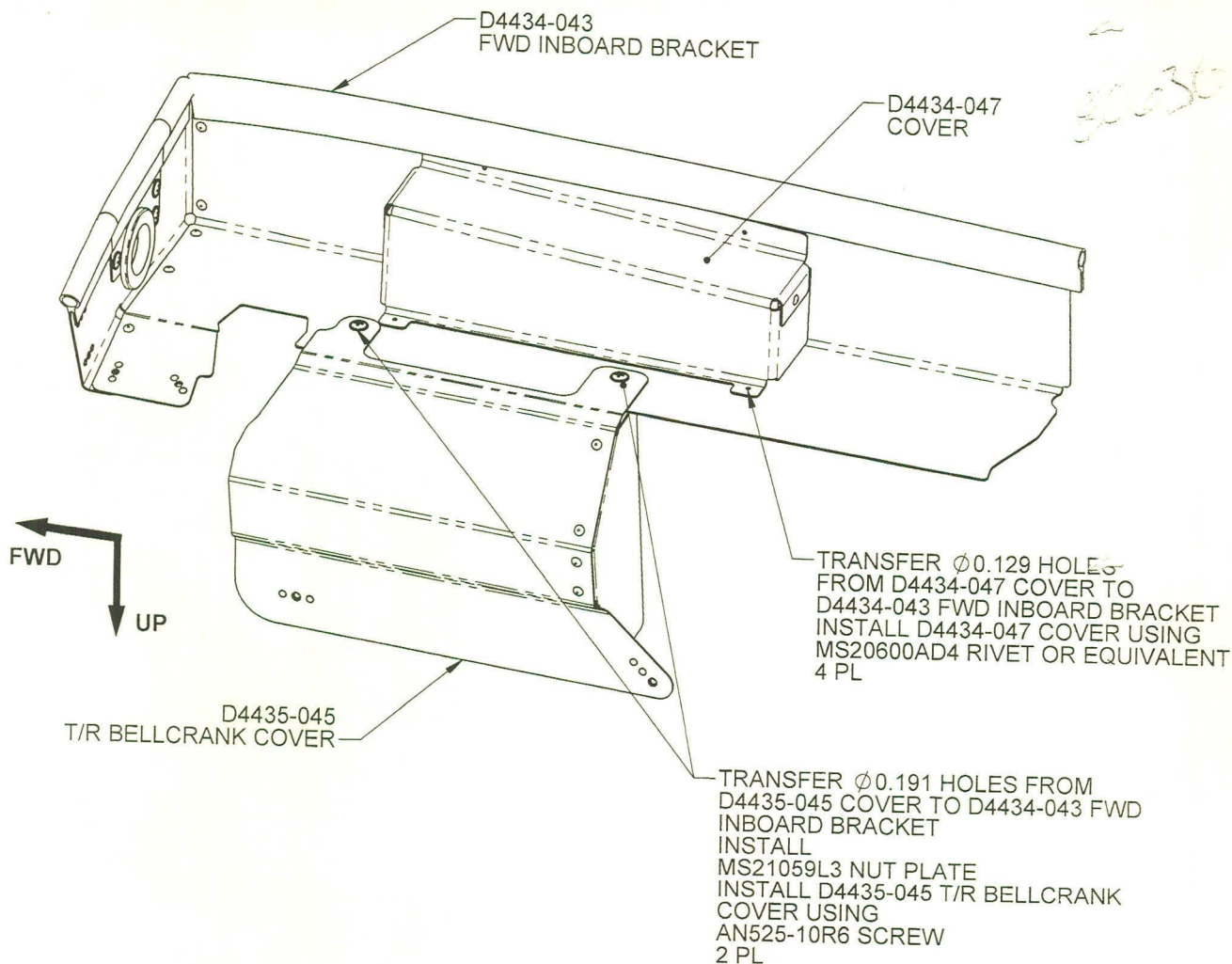


Figure 13. D4435-045 & D4434-047 Cover Installation

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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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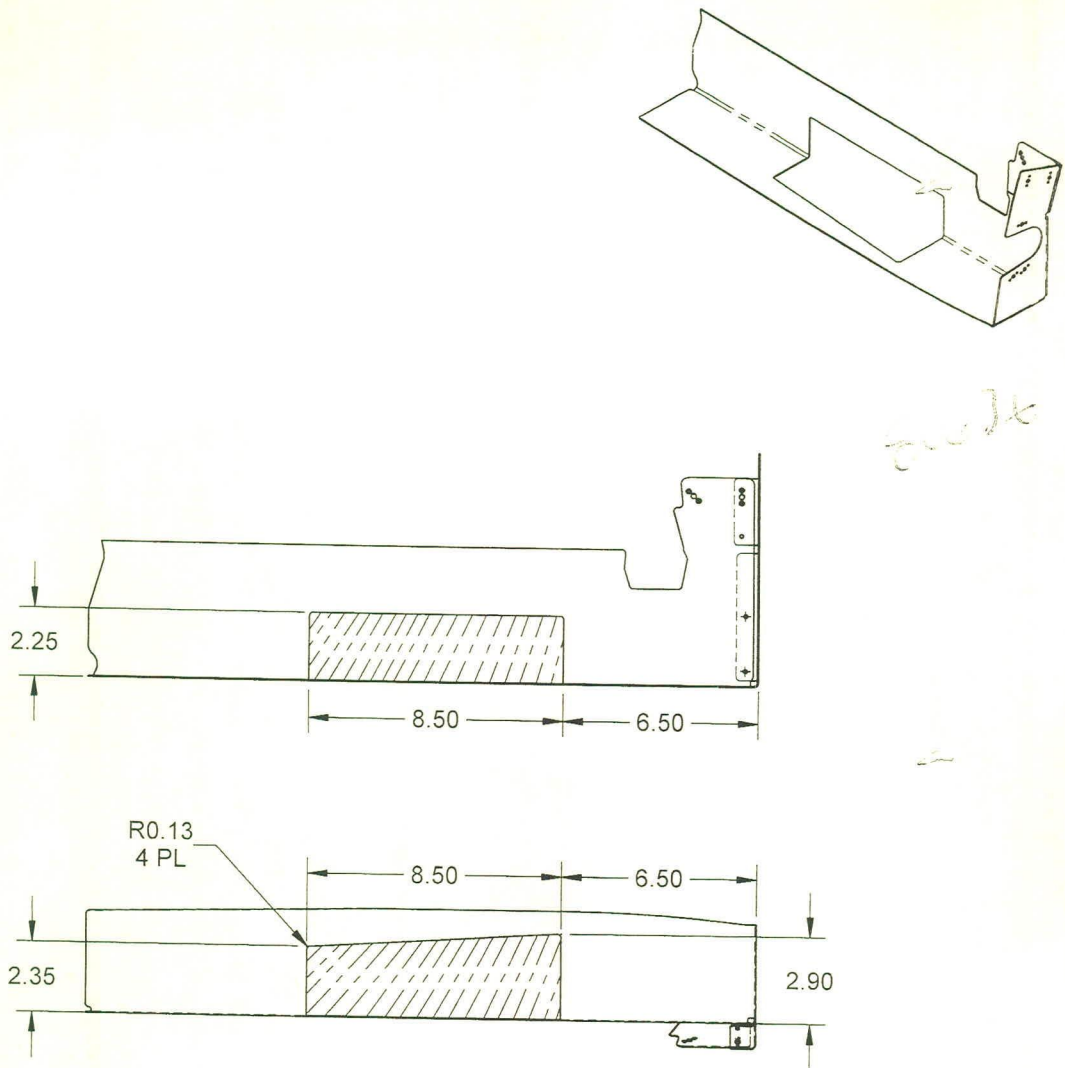


Figure 14. D4434-043 Fwd Inboard Bracket Cutout

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BRANCH
DAO #01-O-01

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